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RB KIT 407M-05
Job Sheet 203469



Part No: RB KIT 407M-05 **Job Qty:** 10 pcs

Part Name: Gauge Pin .0540" dia.



Part Weight: 0 lbs **Status:** New **Priority:** Medium

Job Created: 11/20/19

Job Tracking No:

Due Date: 12/3/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RB KIT 407M REV.D IPP REV A 18.01.25 NEW ISSUE RQ VERIFIED BY DP/IPP Rev B 18.03.08 DWG update Rev. C DP Verify DD/IPP Rev. C 19.01.24 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	10 pcs	12/3/19		0.00	1.25	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
							Small Fab - 9		
120	QC 5	10 pcs	12/3/19		0.00	0.00	QC 5 - 10		GP 19-11-20
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		DAS NOV 28 2019 40 9-89
							QC 5 - 61		
130	Packaging 3-1 - Stock - B4B	10 pcs	12/3/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		

Plex 11/20/19 10:04 AM Dart.lajeunesse.marie

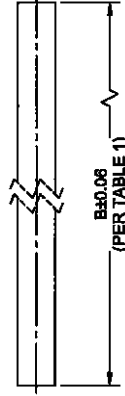
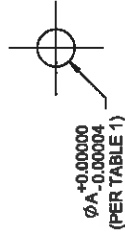
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS 2 9-89
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	10 pcs	12/3/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89

Part Op 100 - (Small Fab) 1-Cut pin in half. 2-Deburr 3-Put pin in small sealable plastic bag with a small amount of LPS 2 to
Descriptions: prevent corrosion. 4-Package as per note 10.
120 - (QC5- Inspect part completeness to step on W/O)
130 - (Identify as per dwg & Stock Location:)
140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
21135A53	Plug Gauge	5 Ea (.5 ea)	100-Small Fab - 1	S220886

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	21135A53	5	24	0

Part Specifications				
Specifications could not be found.				



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 223463 MWS
19-11-20

TABLE 1
GAUGE PIN DIMENSIONS

PART NUMBER	ϕA	B	PURCHASE PART NUMBER (McMASTER CARR)
RB KIT 407M-01	$\phi 0.02400$	1.00"	21135A52 OR EQUIV.
RB KIT 407M-03	$\phi 0.04000$	1.00"	21135A53 OR EQUIV.
RB KIT 407M-05	$\phi 0.05400$	1.00"	21135A53 OR EQUIV.
RB KIT 407M-07	$\phi 0.08000$	1.00"	21135A53 OR EQUIV.
RB KIT 407M-09	$\phi 0.08000$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-11	$\phi 0.08000$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-13	$\phi 0.10800$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-15	$\phi 0.12000$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-17	$\phi 0.14400$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-19	$\phi 0.14400$	0.25"	21135A54 OR EQUIV.
RB KIT 407M-21	$\phi 0.18000$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-23	$\phi 0.18000$	0.25"	21135A54 OR EQUIV.
RB KIT 407M-25	$\phi 0.17280$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-27	$\phi 0.17280$	0.25"	21135A54 OR EQUIV.
RB KIT 407M-29	$\phi 0.18000$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-31	$\phi 0.19200$	1.00"	21135A55 OR EQUIV.

RB KIT 407M-01 THRU -31 ϕ XXXX. CLASS X PLUG NO-GO GAUGE

- NOTES:
1) MATERIAL: SEE TABLE 1 FOR MATERIAL SPECIFICATION
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: XX = $\pm 0.1"$ / $\pm 0.1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A

DESIGN DRAWN	KPT MSB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. D
CHECKED	KPT	TOOL PART #	SHEET 3 OF 8
MFG. APPR.	DP	RB KIT 407M	SCALE
APPROVED	VP	TITLE	N7S
DATE	1/17/2019	SPLINE MEASURING KIT	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation		Disposition			
Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled Other/Details: _____		☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	
		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up		☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread	
		Completed By _____			
		Lead hand / Supervisor _____			
		QC / QA Coordinator _____			